

Work Order ID 66343

Thursday, February 10, 2011 1:36:03 PM



Page 1

Item ID: D206-667-103

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Fwd

Start Date: 2/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mfDate: 11-02-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

8/6/30

HJ for BG 11-3-30

110

0.00



Pick Kit

Packaging

Packaging

Memo

0.00

Packaging

DP

11-3-17

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program

DP

11-3-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00

5/10/11



QC

Memo

0.00



Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Run Start



Stop

Sequence ID/
Work Center ID.Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff (Do not engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

SAD
11-03-20

SAD 11-3-21

①

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

SAD 11-03-22



Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Sub 3/22

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sub 3/22

Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180

0.00



Outsource2

Memo

0.00

Outsource process - NDT

CROSSTUBES

190

0.00



Packaging

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

200

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control



Setup Start

Stop

Cust Item ID:

Customer:



CY 11/03/28 ①

CY 11/03/28 ①

CY 11-07-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 10:00

Finish Time: 11:00

PAINT:

Start Time: 3:00

Finish Time: 4:00

21 11-03-28 (x10)

220

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

8/10/29

(x10)

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



Crosstubes

Crosstubes

Memo

0.00

(ASSEMBLE AS PER DWG D206-667-143)

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI

015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft

holes should be facing up.

A/R Magnobond 6398 : 116677

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

BT 11-03-29

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 03 30 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/305

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8.1/03/30

76

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location: 53

PPP Rev: 3

11/3/305

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/30
mf

11-03-30

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NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 1:35:57 PM

Page 1

Work Order ID: 66343

Parent Item: D206-667-103

Parent Item Name: Crosstube Fwd



Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:
 IPP Rev:H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC
 IPP Rev:I 08-12-15 add magnobond DD verified by:EC
 IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD
 IPP Rev:K 09-01-19 as per DSI9439 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| AN5-30A BOLT | | Purchased | No | | | 250 | Each | 80.0000 | 4 | 4 | | 11/3/30 | |

Location

Loc Qty

Loc Code

ST339

80

114941

30

116003

50

AN5-32A

Bolt

Purchased

No

250

Each

149.0000

4

4

11/3/30

Location

Loc Qty

Loc Code

ST340

149

115016

38

115108

50

115589

60

115698

1

AN5-7A

Bolt

Purchased

No

250

Each

208.0000

10

10

11/3/30

Location

Loc Qty

Loc Code

ST337

208

113149

100

115936

8

116516

100

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66343

Parent Item: D206-667-103

Parent Item Name: Crosstube Fwd

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

34.0000

18 18



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN970-4

Purchased

No

250

Each

67.0000

12 12



Washer

Location

Loc Qty

Loc Code

ST344

67

115936

67

D206-667-103TRN

Manufactured

No

110

Each

2.0000

1 1



Crosstube Turning DetailL

Location

Loc Qty

Loc Code

LG

2

64948

1

64949

1

D2873-043

Manufactured

No

230

Each

24.0000

2 2



Nut Plate Assembly

Location

Loc Qty

Loc Code

LG

22

63497

2

65375

20

ST

2

60981

2

Thursday, February 10, 2011 1:35:58 PM

Shop Packet Print

Page 2

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2873-045

Manufactured No

230

Each

24.0000

2

2



Nut Plate Assembly



RT 11-03-29

Location

Loc Qty

Loc Code

LG

24

60982

4

63498

1

65132

19

x2

D2891-1

Manufactured No

230

Each

39.0000

2

2



2.25 Support



RT 11-03-29

Location

Loc Qty

Loc Code

LG

39

50952

9

53773

20

62595

10

x2

D3595-063-395

Manufactured No

230

Each

115.0000

4

4



RUBBER CUSHION



RT 11-03-29

Location

Loc Qty

Loc Code

FP

10

44667

10

ST

105

63368

45

65361

60

x2

RUBBER CUSHION .63" x 3.95" (4)

Thursday, February 10, 2011 1:35:59 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 1:35:59 PM

Work Order ID: 66343

Parent Item: D206-667-103

Parent Item Name: Crosstube Fwd

Start Date: 2/11/2011

Required Date: 2/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W8

Purchased

No

230

Each

204.0000

14

14



RIVET



11-03-29

Location

Loc Qty

Loc Code

LG

100

116119

100

x14

ST322

104

112203

104

MS21042L5

Purchased

No

250

Each

1,108.000

4

4



Nut



11/3/3059

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1082

115594

386

116105

496

116548

200

MS21920-20

Purchased

No

230

Each

61.0000

4

4



Clamp (per MIL-DTL-8783C)



11-03-29

Location

Loc Qty

Loc Code

LG

61

112624

2

114687

1

115736

8

116799

50

x4

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| Item | Qty -143 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-143 | CROSSTUBE ASSEMBLY (206L HIGH FWD) |
| 2 | 1 | D6002-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2891-1 | SUPPORT |
| 6 | 4 | D3595-063-395 | RUBBER CUSHION |
| 7 | 4 | MS21920-20 | CLAMP (OR MS21920-21) |
| 8 | 14 | MS20601AD4W8 | RIVET (OR NAS9302B-4-8) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

| | | | |
|------------|--|--|--------------|
| C | REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4. | RF | 08.11.06 |
| B | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES | PH | 05.07.26 |
| A | NEW ISSUE | CP | 00.11.17 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | P | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | DRAWING NO. REV. C | |
| CHECKED | P | D206-667-143 | SHEET 1 OF 4 |
| MFG. APPR. | P | TITLE | SCALE |
| APPROVED | P | CROSSTUBE ASS'Y (206L HIGH FWD) | NTS |
| DE APPR. | P | COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.11.06 | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

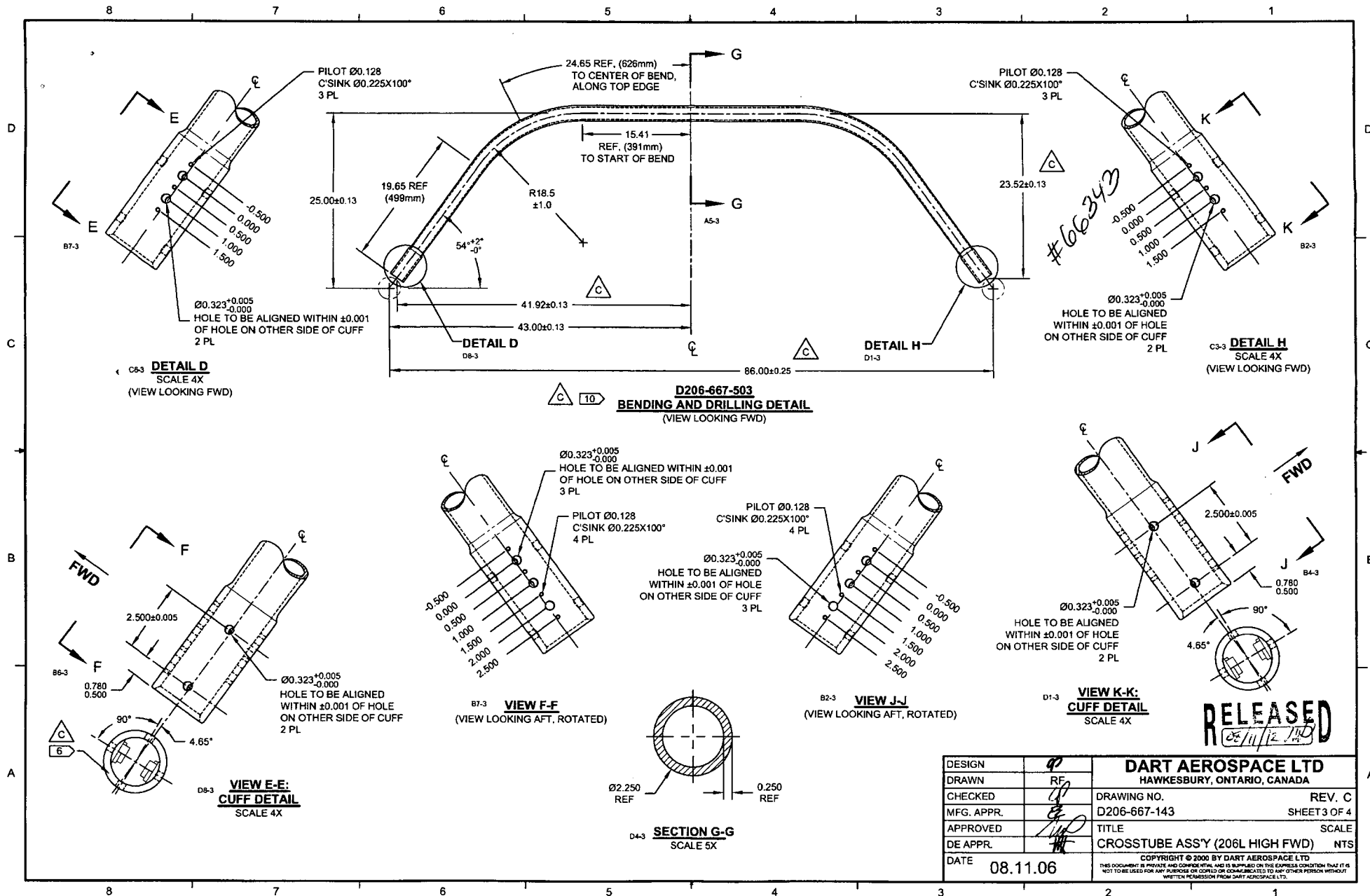
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries



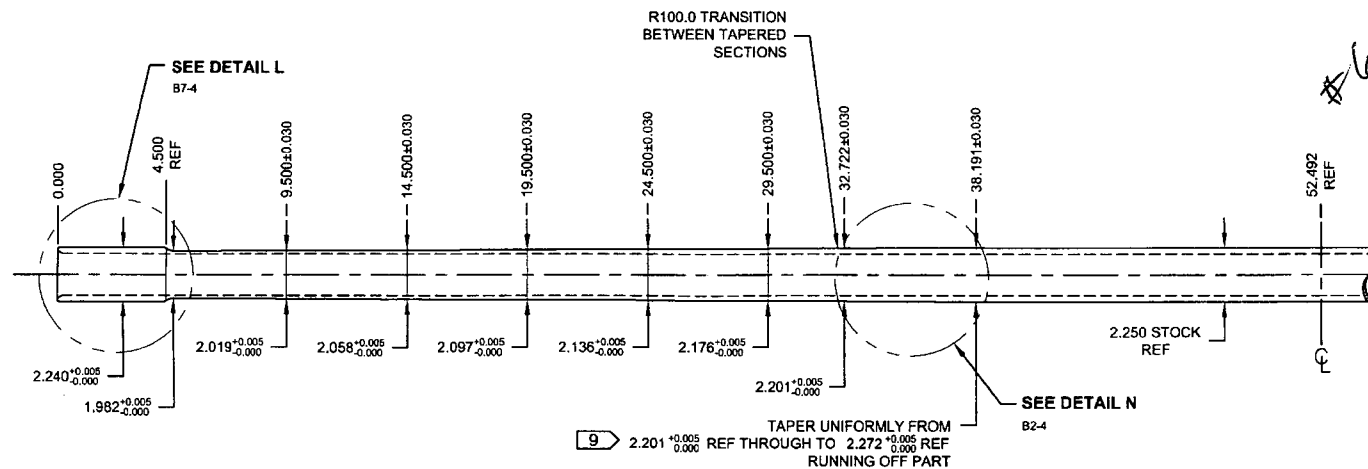
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

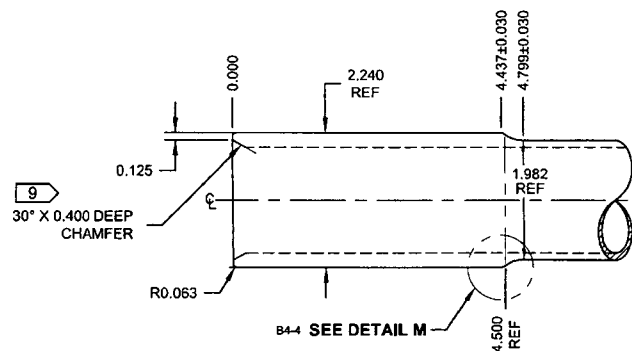
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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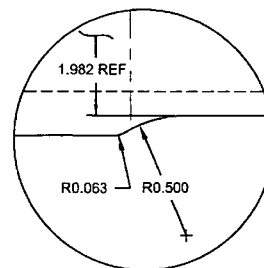
NOTE: Date & initial all entries



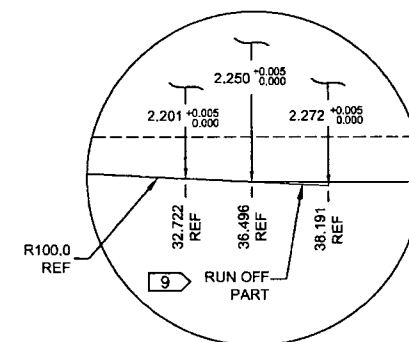
C TURNING DETAIL



**DETAIL L:
CROSSTUBE CUFF**
D7-4 NOT TO SCALE



**DETAIL M:
CUFF TRANSITION**
A6-4 NOT TO SCALE



**DETAIL N:
TAPER RUN-OFF**
C4-4 NOT TO SCALE

RELEASED

| | | | |
|--|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. C |
| MFG. APPR. | RF | D206-667-143 | SHEET 4 OF 4 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | CROSSTUBE ASSY (206L HIGH FWD) | NT |
| DATE | 08.11.06 | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
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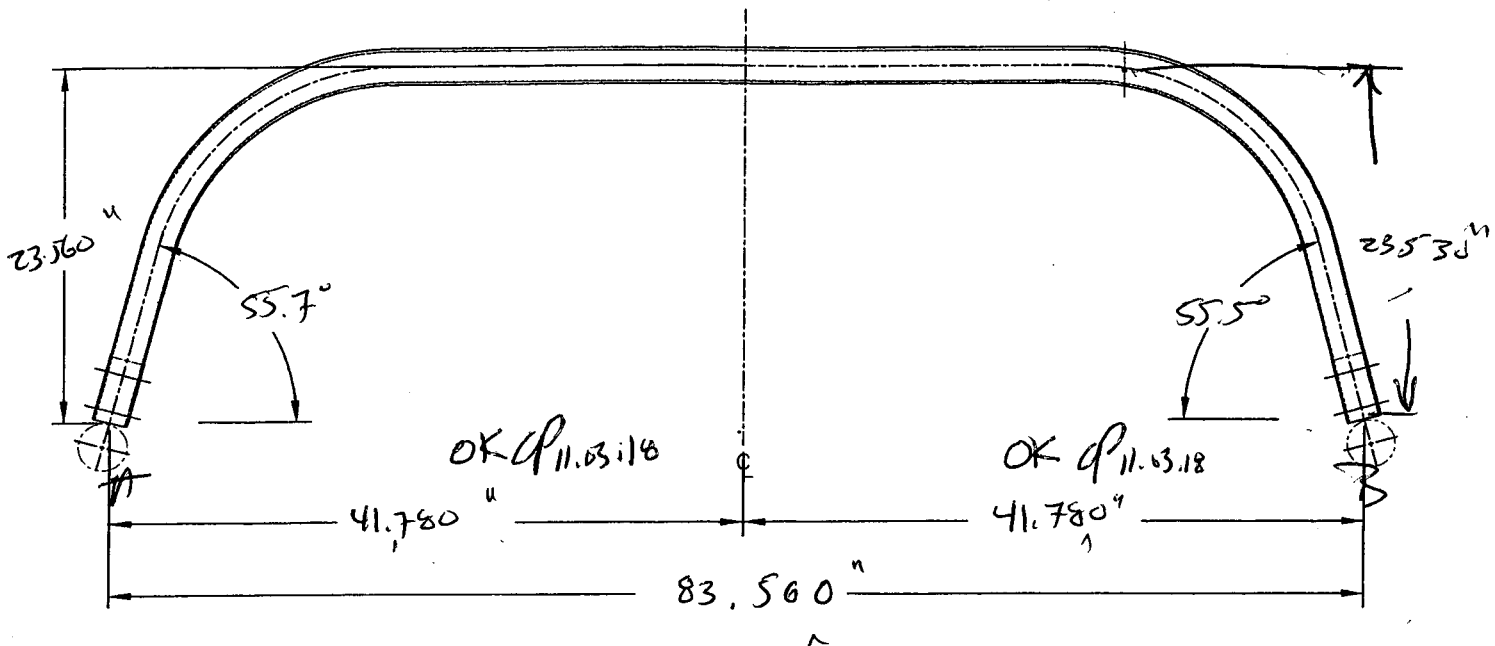
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NOTE: Date & initial all entries

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|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 668.43 |
| Description: Crosstube High Fwd (206L) | | Part Number: | D206-667-103 |
| Inspection Dwg: D206-667-143 Rev: C | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|---------|-------|
| Height | 23.39 | 23.65 |
| 1/2 Span | 41.79 - | 42.05 |
| Angle | 54 | 56 |
| Total Span | 83.58 - | 84.10 |



| Comments |
|------------------------|
| Acceptable CP 11.03.18 |
| |
| |
| |

| | | |
|-----------------|--------------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> | <i>[Signature]</i> |
| Date | 11/03/18 | 11/03/18 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |
| B | 09.06.26 | Dimensions updated per Dwg Rev C | KJ | |
| C | 09.10.22 | Minimum height dimension revised | KJ | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15204

PAGE 1 OF 1

CLIENT DAT Aerospace DATE March 25-2011 TIME AM ☒ PM ☐
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-11-02063
ADDRESS 1220 ABERDEEN ST. POWO No. Q13708
HAWKES BURY, ON. WORK LOCATION HAWKES BURY
KGA I K 7 ACCEPTANCE STD ASTM 1417/MS-038 REV./DATE 2005
PROJECT F.P.I. on cross TUBES TEST
ITEM(S) EXAMINED (4)

JOB DESCRIPTION WET FLOUORESCENT LIQUID PENETRANT INSPECTION PROCEDURE NO. LT-002 REV./DATE 2008 TECHNIQUE NO. LT-1417 REV./DATE 2008
PART NO. — MATERIAL ALUMINUM THICKNESS VARIOUS
SCOPE CARRIED OUT 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L07 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER R20 MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE OCT-19
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)
1 - CrossTUBE : W.O. 66343 ☒ accept reject
1 - CrossTUBE : W.O. 66344 ☒
1 - CrossTUBE : W.O. 67422 ☒
1 - CrossTUBE : W.O. 67398 ☒
11-03-28

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE Jan Titley PRINT Jan Titley SIGNATURE
TECHNICIAN (SIGNATURE): Mike Sutter 1ST TECHNICIAN
NAME (PRINT): Mike Sutter 2ND TECHNICIAN
CGSB LEVEL I SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. 6606 CGSB REG. NO. —
DTR # E-63779
REPORT REVIEWED BY: — NAME — INITIALS —

5.0 PARTS LIST

| Item | Qty -011 | Qty -013 | Qty -015 | Qty -101 | Qty -201 | Qty -103 | Qty -203 | Qty -105 | Qty -205 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|--|
| | X | | | | | | | | | D206-667-011 | SPACER BLOCK KIT |
| | | X | | | | | | | | D206-667-013 | NUT PLATE KIT (-101/-103/-105/-203/-205) |
| | | | X | | | | | | | D206-667-015 | NUT PLATE KIT (-201) |
| | | | | X | | | | | | D206-667-101 | CROSSTUBE INSTALLATION, 206A/B HIGH FWD |
| | | | | | X | | | | | D206-667-201 | CROSSTUBE INSTALLATION, 206A/B HIGH AFT |
| | | | | | | X | | | | D206-667-103 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD |
| | | | | | | | X | | | D206-667-203 | CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT |
| | | | | | | | | X | | D407-667-105 | CROSSTUBE INSTALLATION, 407 HIGH FWD |
| | | | | | | | | | X | D407-667-205 | CROSSTUBE INSTALLATION, 407 HIGH AFT |
| 1 | | | | 1 | | | | | | D206-667-141 | CROSSTUBE ASSEMBLY, 206A/B HIGH FWD |
| 2 | | | | | 1 | | | | | D206-667-241 | CROSSTUBE ASSEMBLY, 206A/B HIGH AFT |
| 3 | | | | | | 1 | | | | D206-667-143 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD |
| 4 | | | | | | | 1 | | | D206-667-243 | CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT |
| 5 | | | | | | | | 1 | | D407-667-145 | CROSSTUBE ASSEMBLY, 407 HIGH FWD |
| 6 | | | | | | | | | 1 | D407-667-245 | CROSSTUBE ASSEMBLY, 407 HIGH AFT |
| 10 | | | | *2 | *2 | *2 | | *2 | | D2891-1 | SUPPORT |
| 11 | | | | | | | *2 | | | D2892-1 | SUPPORT |
| 12 | | | | | | | | | *1 | D2894-1 | SUPPORT |
| 13 | | | | *2 | *2 | *2 | | *2 | | D2856-400-694 | ABRASION STRIP |
| 14 | | | | | | | *2 | | *2 | D2856-400-773 | ABRASION STRIP |
| 15 | | | | | | | | | *1 | D2856-600-851 | ABRASION STRIP |
| 16 | | | | *4 | *4 | *4 | | *4 | | MS21920-20 | CLAMP |
| 17 | | | | | | | *4 | | *4 | MS21920-22 | CLAMP |
| 18 | | | | | | | | | *2 | MS21920-24 | CLAMP |
| 19 | | | | 4 | 4 | 4 | | 4 | | AN5-32A | BOLT |
| 20 | | | | | | | 4 | | 4 | AN5-34A | BOLT |
| 21 | | | | 4 | 4 | 4 | 4 | 4 | 4 | MS21042L5 | NUT (OR MS21042-5) |
| 22 | | | | 8 | 8 | 8 | 8 | 8 | 8 | AN960JD516 | WASHER |
| 23 | | | | | | | | | *2 | D3190-1 | CHAFING SHIELD |
| 30 | 8 | | | | | | | | | AN4-6A | BOLT |
| 31 | 8 | | | | | | | | | AN4-7A | BOLT |
| 32 | 16 | | | | | | | | | AN960JD416 | WASHER |
| 33 | 2 | | | | | | | | | D3193-041 | SPACER BLOCK ASSEMBLY |
| 40 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-043 | NUT PLATE |
| 41 | | 2 | | *2 | | *2 | *2 | *2 | *2 | D2873-045 | NUT PLATE |
| 42 | | | 2 | | 2 | | | | | D2872-043 | NUT PLATE |
| 43 | | | 2 | | 2 | | | | | D2872-045 | NUT PLATE |
| 44 | | 10 | | 10 | | 10 | | | | AN5-7A | BOLT |
| 45 | | 10 | 10 | | 10 | | 10 | 10 | 10 | AN5-10A | BOLT |
| 46 | | 4 | 4 | 4 | 10 | 4 | 4 | 4 | 4 | AN5-30A | BOLT |
| 47 | | 4 | | | | | 4 | | 4 | AN5-32A | BOLT |
| 48 | | 18 | 18 | 10 | 12 | 10 | 10 | 10 | 10 | AN960JD516 | WASHER |
| 49 | | 4 | 4 | | 6 | | | | | MS21042L5 | NUT (OR MS21042-5) |

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C

Date: 05.07.26

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2

REF CANADIAN STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC: EASA.IM.R.S.01179

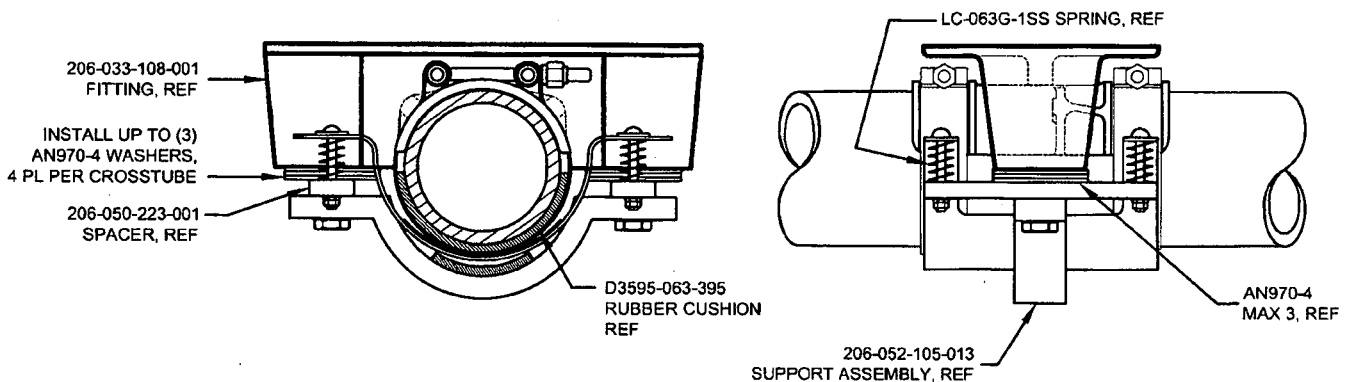
REFERENCE ONLY

PROBLEM:

FOR D206-667-103 CROSSTUBES (206L FWD) AT CHG 003 AND SUBSEQUENT (SEE DSI 9415) PROPER INSTALLATION OF THE OEM SUPPORT ASSEMBLIES MAY BE IMPOSSIBLE DUE TO THE ADDITIONAL THICKNESS OF THE DART D3595-063-395 RUBBER CUSHIONS. THE 206-052-105-013 SUPPORT ASSEMBLY (OR EQUIVALENT) MAY SIT TOO HIGH RELATIVE TO THE 206-033-108-001 FITTING, CAUSING THE LC-063G-1SS SPRING (OR EQUIVALENT) TO BE OVERLY COMPRESSED.

SOLUTION:

IT IS ACCEPTABLE TO LOWER THE SUPPORT ASSEMBLY BY INSTALLING UP TO QTY (3) AN970-4 WASHERS BETWEEN THE 206-033-108-001 FITTING (OR EQUIVALENT) AND THE 206-050-223-001 SPACER (OR EQUIVALENT). SEE FIGURE BELOW FOR REFERENCE.



CROSSTUBE SECTION: SUPPORT DETAIL

PARTS LIST:

THE FOLLOWING PARTS HAVE BEEN INCLUDED WITH D206-667-103 CROSSTUBES AT CHG 004 AND SUBSEQUENT

| ITEM | Qty -103 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|
| 60 | 12 | AN970-4 | WASHER |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.12.17
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| MFG. APPR. | N/A | DSI 9439 | SHEET 1 OF 1 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 206L FWD XTUBE SUPPORT MOD. | NTS |
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